

C6611677

MODEL 700™ M24

Model **SMS**™

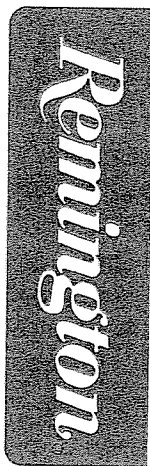
Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.





**MODEL 700™**  
**M24**



RES. US PAT. & TM. OFF.

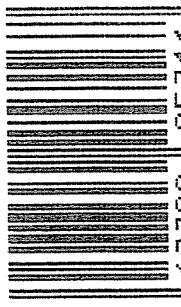
VERY IMPORTANT!  
 Instruction Book  
 enclosed to assure  
 safe use of this  
 firearm.

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

**SERIAL NO.**  
**C6611677**

**ORDER NO.**  
**5716**

UPC



0 47700 25716 7



5716 C6611677

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611677

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 3 28     | 91      | Rw   |
| 600          | Proof                                                          | 3 28     | 91      | Rw   |
| 607          | Check Headspace                                                | 3 28     | 91      | Rw   |
| 610          | Dis-assemble Gun                                               | 3 28     | 91      | Rw   |
| 612          | Magnaflux Barrel<br>Action                                     | APR      | 2 1991  | KR   |
|              | Magnaflux Bolt                                                 | APR      | 2 1991  | "    |
| 615          | Rollmark Caliber                                               | APR      | 2 1991  | LG   |
| 617          | Drill and Tap Sight Holes                                      | APR      | 5 1991  | LB   |
| 618          | Polish Barrel                                                  | APR      | 5 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 4-9-91  | TA   |
|              | Apply Coating (Bolt)                                           |          |         | P    |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 4/16/91 | Rw   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 4/16/91 | Rw   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 4/16/91 | Rw   |
|              | D) Oil Firing Pin Ass'y                                        |          | 4/16/91 | Rw   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 5/1/91  | JA   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6    | 6    |      |      | 5/1/91  | RL   |
|              | G) Safety Off Force                                         | 4        | 4    | 4    |      |      | 5/1/91  | RL   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 5/1/91  | RL   |
|              | I) Firing Pin Indent                                        | .0205    | .021 | .021 |      |      | 5/1/91  | RL   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 5/2/91  | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 5-16-91 | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 5/2/91  | RW   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 5/2/91  | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 5/2/91  | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 5/2/91  | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 5/2/91  | RW   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 5-2-91  | AF   |
|              | A) Time                                                     |          |      |      |      |      | "       | AF   |
|              | B) Malfunctions                                             |          |      |      |      |      | "       | AF   |
|              | C) Pierced Primers                                          |          |      |      |      |      | "       | AF   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | "       | AF   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 5-2-91  | AF   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 5-16-91 | DH   |
|              | B) Trigger Pull                                             | 2.24     | 2.20 | 2.20 | 2.20 | 2.22 | 5/10/91 | RL   |
|              | C) Function                                                 |          |      |      |      |      | 5-16-91 | DH   |
| 660          | Pack                                                        |          |      |      |      |      | 6-16-91 | AF   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611677

DATE 5/1/91

TESTER JRU

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.43             | 2.23                     | 2.20                           | 2.24 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.32             | 2.31                     | 2.24                           | 2.20 |                                                                        |
| PULL #3 | 2.30             | 2.26                     | 2.28                           | 2.20 |                                                                        |
| PULL #4 | 2.30             | 2.18                     | 2.20                           | 2.20 |                                                                        |
| PULL #5 | 2.32             | 2.24                     | 2.23                           | 2.22 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.37             | 3.40                     |  |          |
| PULL #2 | 3.42             | 3.40                     |  |          |
| PULL #3 | 3.38             | 3.35                     |  |          |
| PULL #4 | 3.39             | 3.35                     |  |          |
| PULL #5 | 3.41             | 3.38                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.38             | 4.26                     |                                | 4.23                                 |
| PULL #2 | 4.33             | 4.15                     |                                | 4.38                                 |
| PULL #3 | 4.17             | 4.29                     |                                | 4.35                                 |
| PULL #4 | 4.31             | 4.38                     |                                | 4.35                                 |
| PULL #5 | 4.32             | 4.36                     |                                | 4.41                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611677  
2 May 1991

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .14798   |
| 1 TO | 2 | .0266271 |
| 1 TO | 3 | .0961665 |
| 1 TO | 4 | .459479  |
| 1 TO | 5 | .149626  |

4  
3

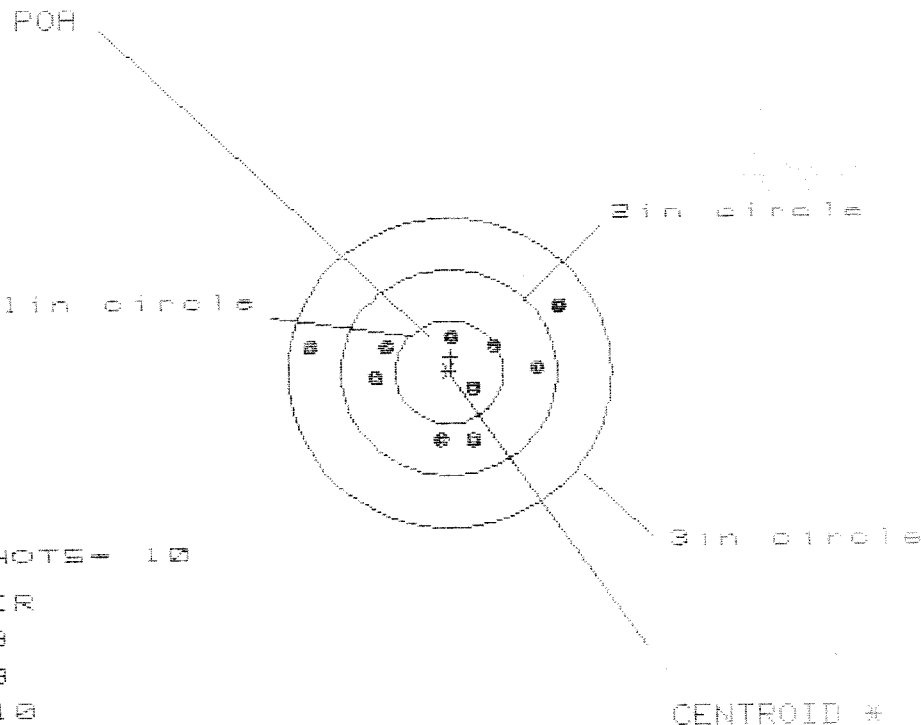
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0074  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0098  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0122801  
THE AMR FOR THIS RIFLE IS: .825

2 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/CGB11677

# CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.310

VS= 1.292

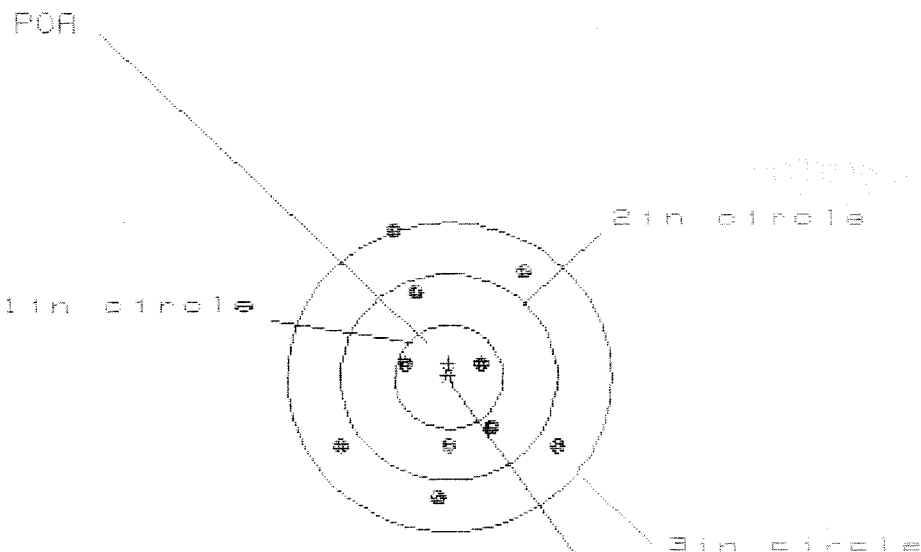
GS= 2.345

| PATTERN #                   | : | 1      | 9     | 8     |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .988   | .841  | .771  |
| MINIMUM X                   | : | -1.322 | -.800 | -.695 |
| MAXIMUM Y                   | : | .602   | .624  | .398  |
| MINIMUM Y                   | : | -.690  | -.668 | -.590 |
| CENTROID X                  | : | -.017  | .130  | .025  |
| CENTROID Y                  | : | -.147  | -.169 | -.247 |
| POA TO CENTROID in.         | : | .148   | .213  | .248  |
| MIN RADIUS                  | : | .294   | .179  | .207  |
| MEAN RADIUS                 | : | .701   | .610  | .555  |
| MAX RADIUS                  | : | 1.337  | 1.047 | .782  |
| HORIZONTAL SPREAD           | : | 2.310  | 1.641 | 1.466 |
| VERTICAL SPREAD             | : | 1.292  | 1.292 | .988  |
| EXTREME SPREAD              | : | 2.345  | 1.774 | 1.470 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS - 10

# IN CIR

1in = 2

2in = 5

3in = 9

HE = 1.961

VS = 2.556

GS = 2.590

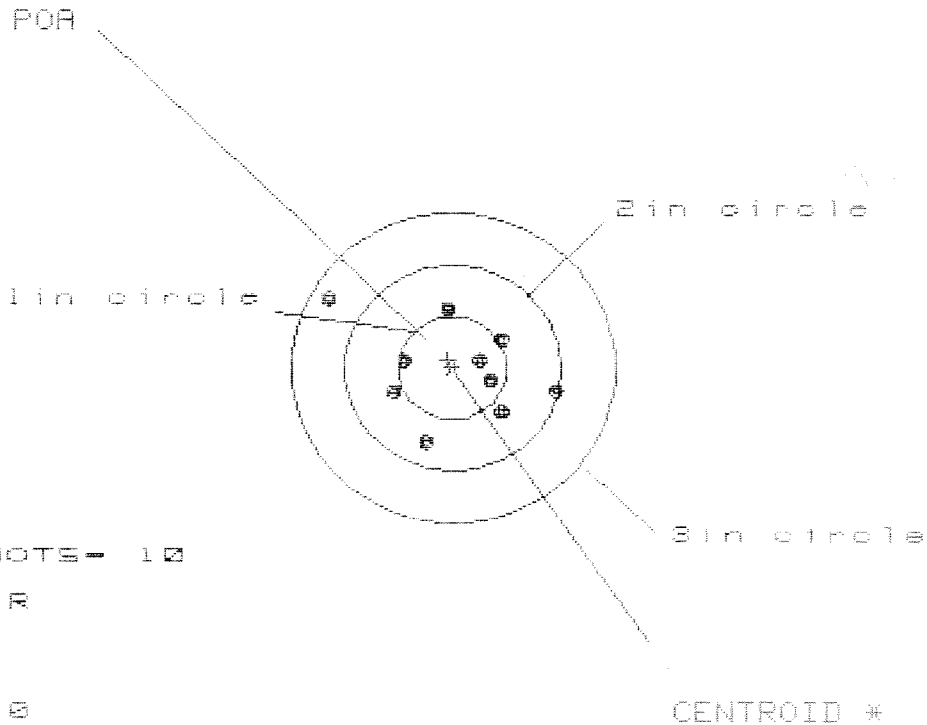
CENTROID #

| PATTERN #                   | : | 2      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .999   | .938   | 1.014 |
| MINIMUM X                   | : | -.962  | -1.023 | -.947 |
| MAXIMUM Y                   | : | 1.415  | 1.179  | 1.182 |
| MINIMUM Y                   | : | -1.141 | -.984  | -.837 |
| CENTROID X                  | : | .005   | .066   | -.010 |
| CENTROID Y                  | : | -.132  | -.289  | -.436 |
| POA TO CENTROID in.         | : | .132   | .296   | .436  |
| MIN RADIUS                  | : | .398   | .399   | .327  |
| MEAN RADIUS                 | : | .917   | .831   | .752  |
| MAX RADIUS                  | : | 1.518  | 1.328  | 1.219 |
| HORIZONTAL SPREAD           | : | 1.961  | 1.961  | 1.961 |
| VERTICAL SPREAD             | : | 2.556  | 2.163  | 2.019 |
| EXTREME SPREAD              | : | 2.590  | 2.362  | 2.027 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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# CENTERFIRE PATTERNS # 3



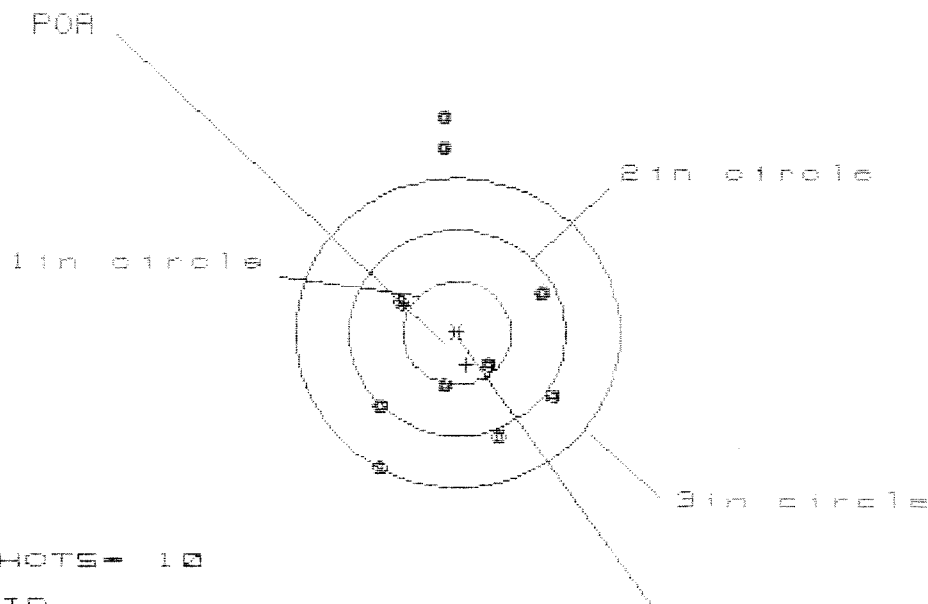
# OF SHOTS - 10  
 # IN CIR  
 1in = 3  
 2in = 8  
 3in = 10  
 HS = 2.096  
 VS = 1.432  
 GS = 2.274

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 3      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .910   | .779  | .460  |
| MINIMUM X                   | : | -1.186 | -.635 | -.538 |
| MAXIMUM Y                   | : | .683   | .649  | .633  |
| MINIMUM Y                   | : | -.749  | -.673 | -.689 |
| CENTROID X                  | : | .051   | .182  | .085  |
| CENTROID Y                  | : | -.079  | -.155 | -.139 |
| POA TO CENTROID in.         | : | .094   | .239  | .163  |
| MIN RADIUS                  | : | .275   | .207  | .269  |
| MEAN RADIUS                 | : | .652   | .546  | .523  |
| MAX RADIUS                  | : | 1.368  | .789  | .735  |
| HORIZONTAL SPREAD           | : | 2.096  | 1.414 | .998  |
| VERTICAL SPREAD             | : | 1.432  | 1.322 | 1.322 |
| EXTREME SPREAD              | : | 2.274  | 1.420 | 1.331 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 9     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 5

3in = 7

HS= 1.617

VS= 3.374

CS= 3.438

CENTROID #

|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 4      |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .875   | .866   | .851  |
| MINIMUM X                   | : | -.742  | -.751  | -.766 |
| MAXIMUM Y                   | : | 2.044  | 1.997  | .840  |
| MINIMUM Y                   | : | -1.330 | -1.103 | -.854 |
| CENTROID X                  | : | -.081  | -.073  | -.058 |
| CENTROID Y                  | : | .308   | .081   | -.168 |
| POA TO CENTROID in.         | : | .319   | .109   | .178  |
| MIN RADIUS                  | : | .416   | .264   | .104  |
| MEAN RADIUS                 | : | 1.087  | .920   | .735  |
| MAX RADIUS                  | : | 2.045  | 2.000  | 1.147 |
| HORIZONTAL SPREAD           | : | 1.617  | 1.617  | 1.617 |
| VERTICAL SPREAD             | : | 3.374  | 3.100  | 1.693 |
| EXTREME SPREAD              | : | 3.438  | 3.164  | 2.283 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |       |

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# CENTERFIRE PATTERNS

# 5

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.757

VS= 1.693

GS= 2.171

PATTERN #

5

|                               |   |       |       |       |
|-------------------------------|---|-------|-------|-------|
| SHOTS (BEST OF)               | : | 10    | 9     | 8     |
| MAXIMUM X                     | : | .958  | 1.030 | .943  |
| MINIMUM X                     | : | -.799 | -.693 | -.759 |
| MAXIMUM Y                     | : | .809  | .711  | .588  |
| MINIMUM Y                     | : | -.884 | -.982 | -.772 |
| CENTROID X                    | : | .005  | -.101 | -.014 |
| CENTROID Y                    | : | .001  | .099  | .222  |
| POA TO CENTROID in.           | : | .006  | .142  | .222  |
| MIN RADIUS                    | : | .151  | .037  | .114  |
| MEAN RADIUS                   | : | .768  | .692  | .625  |
| MAX RADIUS                    | : | 1.303 | 1.202 | .945  |
| HORIZONTAL SPREAD             | : | 1.757 | 1.723 | 1.782 |
| VERTICAL SPREAD               | : | 1.693 | 1.693 | 1.360 |
| EXTREME SPREAD                | : | 2.171 | 2.076 | 1.748 |
| NUMBER IN ONE INCH CIRCLE =   |   |       | 2     |       |
| NUMBER IN TWO INCH CIRCLE =   |   |       | 8     |       |
| NUMBER IN THREE INCH CIRCLE = |   |       | 10    |       |